

Date: Monday, 12/01/2009 2:37:47 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	GASKET
Job Number :	44680		
Estimate Number :	13035		
P.O. Number :		Part Number :	D36821
This Issue :	12/01/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3682 REV.A
First Issue :	/ /	Project Number :	N/A
Previous Run :	43924	Drawing Revision :	A
	Type :	Material :	
	SMALL /MED FAB	Due Date :	20/02/2009
Written By :		Qty:	10
Checked & Approved By :	JLD 09.01.13	Um:	Each
Comment :	Est Rev:A New Issue 07-09-27 DD verified by: EC Est Rev:B ecn1162 08-04-02 DD verified by:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	G89	coated cloth
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Comment: Qty.: 0.3258 sf(s)/Unit Total : 3.2582 sf(s)

G-89 coated cloth

Batch: 109805 HB 9-1-31

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3682

Dwg Rev: A
 Prog Rev: A

HB 9-1-31



2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 9-1-31

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 09102102



5.0	PACKAGING 1	PACKAGING RESOURCE #1
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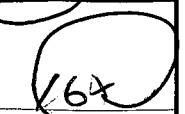


Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location 177

9/12/12



SB

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 44680

Part Number: D36821

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/02 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-02-02

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: H4680
Description: Gasket		Part Number: D3682-1
Inspection Dwg: D3682	Rev: A	Page 1 of 1

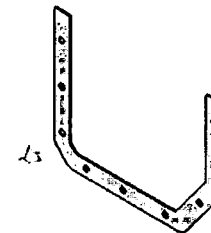
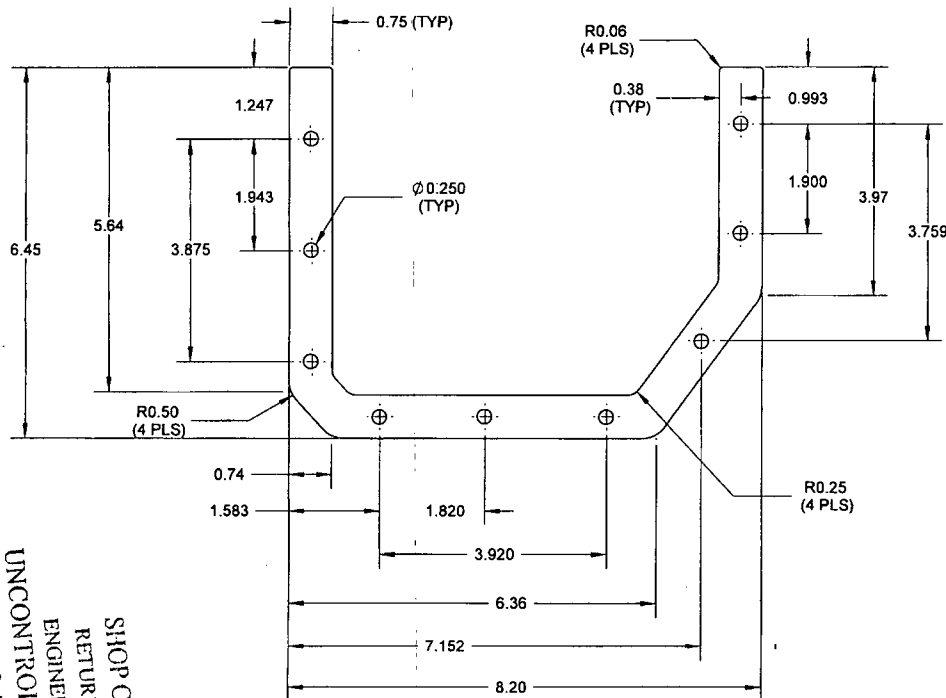
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.250	+0.005/-0.001	.255	X			
0.75	+/-0.030	.745	X			
1.247	+/-0.010	1.244	X			
1.943	+/-0.010	1.938	X			
3.875	+/-0.010	3.879	X			
6.45	+/-0.030	6.444	X			
1.583	+/-0.010	1.581	X			
1.820	+/-0.010	1.824	X			
3.920	+/-0.010	3.925	X			
7.152	+/-0.010	7.159	X			
8.20	+/-0.030	8.20	X			
0.993	+/-0.010	.990	X			
1.900	+/-0.010	1.906	X			
3.759	+/-0.010	3.762	X			
0.38	+/-0.030	.388	X			

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 9-1-31	Date: 02/02/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	KJ/DD	AS



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK CONTINUED
NO. 141680

D3682-1 GASKET

NOTES:

- 1) MATERIAL: THERMO-CHEM P/N G-89, (REF. 0.060 THICK)
POSSIBLE SUPPLIER: A.R. THOMSON GROUP
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3682-1 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.05 lbs

A NEW ISSUE		RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.11.07		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3682 TITLE GASKET SCALE 1:2 REV. A SHEET 1 OF 1 COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			